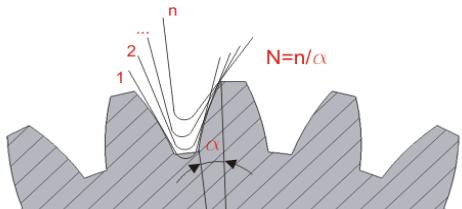


Shaper Cutter Ø126 Z28

A12-230

Evolvent-Grinding is based on an oscillation grinding principle and can only be achieved with the mechanically adapted machine: Linear axis, automatic dressing. The Fanuc control used on our GEMINI DMR allows an optimized parameterization for a smooth behaviour of the fast moving linear axis.



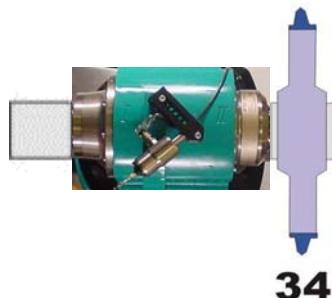
1. Cycletime for Production

Tool specifications							
	Diameter 126 mm, Z 28, Length of cutting edge 20 mm, Helix angle 0.001°						
Material HSS	Grinding stock 0.3mm						
Operations	Probe	3xPregrind	3xDress	Prefinish	Dress	Finish	Sparkout
Feed [mm/Min]	2000	12000	100	12000	100	12000	12000
Power [kW]		2	1	2	1	2	1
Cutting feed [m/s]		32	16	32	16	32	16
Used wheels							
Grinding time [s]	42	4600	160	1536	54	1536	1560
Total cycle time	158 Min 08						

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

34 DXF Ø200 C120



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR Linear, dressing unit
 Control: Fanuc 31i
 Coolant: Synthetic Oil, pressure 16 bar
 Software: Quinto 5

responsible engineer: OP,9.4.09

www.schneeberger.ch

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TECHNOLOGY
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